

6/18/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

011740



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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D5387-041

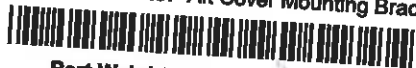
Job Sheet 196659



Part No: D5387-041

Job Qty: 10 pcs

Part Name: Aft Cover Mounting Bracket Assembly



Part Weight: 0 lbs

Job Created: 6/18/19

Due Date: 7/12/19

Type: Stock

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG REV A IPP REV:A 16.04.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Waterjet - Flow - 1	10 pcs		7/12/19	0.17	0.33	Waterjet - Flow		
110	QC 2	10 pcs		7/12/19	0.00	0.00	QC 2 - 1		02/19/08/24
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		02/19/08/24
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

PRIORITY

011740

6/18/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120 QC 8	10 pcs	7/12/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - Brake NC - B4B	10 pcs	7/12/19	0.25 0.04	Small Fab - Brake - 1 - B4B	DAS 30 9-89
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	10 pcs	7/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
150 Handfinish - 1-1 Chemical- B4B	10 pcs	7/12/19	0.00 0.50	Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	

DAS
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9-89

AUG 26 2019

SEP 13 2019

smb 19/8/28

DAS
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SEP 03 2019

SEP 03 2019

					Handfinish - 1 - 8 - B4B				
					Handfinish - 1 - 9 - B4B				
					Handfinish - 1 - 10 - B4B				
					Handfinish - 1 - 11 - B4B				
					Handfinish - 1 - 12 - B4B				
					Handfinish - 1 - 13 - B4B				
					Handfinish - 1 - 14 - B4B				
					Handfinish - 1 - 15 - B4B				
					Handfinish - 1 - 16 - B4B				
					Handfinish - 1 - 17 - B4B				
					Handfinish - 1 - 18 - B4B				
					Handfinish - 1 - 19 - B4B				
					Handfinish - 1 - 20 - B4B				
					Handfinish - 1 - 21 - B4B				
					Handfinish - 1 - 22 - B4B				
160 QC 7	10 pcs	7/12/19	0.00 0.00	QC 7 - 10					
				QC 7 - 13					
				QC 7 - 14					
				QC 7 - 15					
				QC 7 - 17					
				QC 7 - 18					
				QC 7 - 19					
				QC 7 - 2					
				QC 7 - 28					
				QC 7 - 3					
				QC 7 - 30					
				QC 7 - 34					
				QC 7 - 36					
				QC 7 - 37					
				QC 7 - 41					
				QC 7 - 47					
				QC 7 - 48					
				QC 7 - 51					
				QC 7 - 58					
				QC 7 - 59					
				QC 7 - 60					
				QC 7 - 9					
				QC 7 - 68					
				QC 7 - 50					
				QC 7 - 67					
				QC 7 - 40					
				QC 7 - 24					
				QC 7 - 43					
				170 Powdercoat - 4 Black Sand - B4B	10 pcs	7/12/19	0.00 0.14	Powdercoat - 1 - B4B	
								Powdercoat - 2 - B4B	
Powdercoat - 3 - B4B									
Powdercoat - 4 - B4B									
180 QC 3	10 pcs	7/12/19	0.00 0.00	QC 3 - 10					
				QC 3 - 13					

17 138839.

START: 2:15 O.V.T. 320° Finish: 2:45

BR 19-9-3

BR 19-9-3.

Plex 6/18/19 12:48 PM Dart.lajeunesse.marie

M 138839.

START: 2:15 A.T. 3:00° Finish: 2:45

BK 19-9-3

BK 19-9-3

						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	DAS 30 9-89
						QC 3 - 34	SEP 04 2019
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
190 Small Fab - 2 - B4B	10 pcs	7/12/19	0.00 0.42			Small Fab - 1 - B4B	
						Small Fab - 2 - B4B	
						Small Fab - 3 - B4B	
						Small Fab - 4 - B4B	
						Small Fab - 5 - B4B	SEP 04 2019
						Small Fab - 6 - B4B	
						Small Fab - 7 - B4B	
200 QC 5	10 pcs	7/12/19	0.00 0.00			QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	DAS
						QC 5 - 9	81
						QC 5 - 50	9-89
						QC 5 - 30	SEP 04 2019
						QC 5 - 40	
210 Packaging 3-1 - Stock - B4B	10 pcs	7/12/19	0.00 0.00			Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	ST 160
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	

Wed 9-3-2019
Rosales, Oscar

					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220	QC 21 - SA	10 pcs	8/5/19	0.00 0.00	QC 21 - SA - 21 →	ST160
					QC 21 - SA - 70	
					QC 21 - SA - 53	

DAS
21
9-29

SEP 04 2019

Part Op 100 - Waterjet - Flow)

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Bend/Assemble as per dwg)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (QC7-Inspect Chemical Conversion Coat)

170 - Powdercoat4 (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3)

180 - (QC3- Inspect Part Finish)

190 - (Small Fab)

200 - (QC5- Inspect part completeness to step on W/O)

210 - (Identify as per dwg & Stock Location: _____)

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.032	6061-T6 Sheet 0.032"	.5000 sf (.05 ea)	100-Waterjet - Flow - 1	S152117
MS20426AD3-3	Rivet	20 Ea (2 ea)	190-Small Fab - 2 - B4B	8174291
MS21059L3	Nut Plate	10 Ea (1 ea)	190-Small Fab - 2 - B4B	6x8 203338-4x5168612

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.032	1	123	0
190-Small Fab - 2 - B4B	MS20426AD3-3	20	5,965	0
	MS21059L3	10	155	10

Allocated Container Detail

Qty	Container No	Location	Init
4	S211117	st301	_____
6	S203338	st301	_____

Part Specifications

Specifications could not be found.

Plex 9/4/19 7:45 AM dart.boucher.sylvie

INSPECTION SHEET

**DAS
40**

Engineering Approval:
(If necessary)

H:\FORMS\Quality Assurance\approved QA\Inspection Sheet revB

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____		DISPOSITION				DEPARTMENT / PROCESS													
Part No. _____		Rework Scrap Use-as-is				Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality							
Date :	Sequence #:	QTY Affected :		MRB (QSI042)															
Description Work Order Deviation				Disposition															
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY															
				Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled				Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function				Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up				Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
				Other/Details:															
				Completed By															
				Lead hand / Supervisor															
				QC / QA Coordinator															